

What is claimed :

1 1. A method for manufacturing a part (4, 5) of a
2 sports boot (1) in composite material from flat
3 elements (21, 22), which comprises the following steps:

4 - preparing a first blank (22) in a first flexible
5 material intended to form the external face of the
6 boot part, and a second blank (21) in a second
7 flexible material intended to form the internal
8 face of the boot part (4, 5),

9 - placing the first and second blanks on the
10 impression of a first half (31) of a mold (30),
11 with the first blank (22) against the impression,

12 - closing the mold (30) by using its second half
13 (32),

14 - injecting a foamable binding material between
15 the blanks (21, 22), and

16 - mold release after polymerization of the
17 injected material so as to obtain the boot part
18 (4, 5).

1 2. The method as claimed in claim 1, wherein the part
2 (4, 5) of the sports boot is a part of the upper of the
3 boot.

1 3. The method as claimed in claim 1, wherein the
2 first material comprises a synthetic fabric.

1 4. The method as claimed in claim 1, wherein the
2 first material comprises an elastic fabric.

1 5. The method as claimed in claim 1, wherein the
2 first material is waterproofed by an elastomer.

1 6. The method as claimed in claim 1, wherein the
2 first material has a thickness of from 0.8 to 1 mm.

1 7. The method as claimed in claim 1, wherein the
2 second material comprises a synthetic fabric.

1 8. The method as claimed in claim 1, wherein the
2 second material comprises an elastic fabric.

1 9. The method as claimed in claim 1, wherein the
2 second material comprises a polyester felt.

1 10. The method as claimed in claim 1, wherein the
2 injected material is a polyurethane foam.

1 11. The method for manufacturing a part of a sports
2 boot (1) as claimed in claim 1, wherein at least one
3 element (9a, 10, 11, 12, 23) is affixed to at least one
4 of the blanks (21, 22), which is intended to form the
5 internal or external face of the part, before it is
6 placed in the injection mold (30).

1 12. The method as claimed in claim 11, wherein the
2 affixed part is a decorative pattern (23) applied by a
3 screen printing method.

1 13. The method as claimed in claim 11, wherein the
2 affixed element is an eyelet (9a) for a lace.

1 14. The method as claimed in claim 11, wherein the
2 affixed element is a ring (10) for gripping.

1 15. The method as claimed in claim 11, wherein the
2 affixed element is a watertight flap (11).

1 16. The method as claimed in claim 11, wherein the
2 affixed element is a protecting tongue (12).

1 17. The method as claimed in claim 11, wherein the
2 affixed element is a reinforcing element.

1 18. The method as claimed in claim 11, wherein the
2 affixed element is a comfort element having a density
3 different to that of the injected foamable material.

1 19. The method as claimed in claim 11, wherein the
2 affixed element is a compartment intended to hold an
3 injected personalization material.

1 20. A method for manufacturing an upper (2) of a
2 sports boot (1), wherein parts (4, 5) of an upper which
3 have been produced as claimed in claim 1 are assembled.

1 21. An upper (2) of a sports boot obtained by the
2 method as claimed in claim 20.